

Date: Monday, 02/03/2009 11:25:33 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 46189	
Estimate Number : 13350	
P.O. Number :	Part Number : D35891
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3589 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 44934	Material :
Written By :	Due Date : 16/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.03.02</u>	
Comment : Est Rev:A 08-05-29 new issue DD verified by:EC Est Rev:B 09-02-20 rev.b asper dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0375W065

304 RD Tube .375 x .065W



Comment: Qty.: 1.6520 f(s)/Unit Total : 9.9118 f(s)

304 RD Tube .375 x .065W

batch: M18993 (2X)

M18457 (4X)

EJ 09/04/15

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- cut D3589-1 as per dwg D3589

2- chamfer both ends as per dwg D3589

3- deburr

EJ 09/04/15 (6)

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

S 09/04/15 (6)

4.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: SK 1/6

A 09/04/15

5.0

QC21

FINAL INSPECTION/W/O RELEASE

**Comment:** FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



TUF 09-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

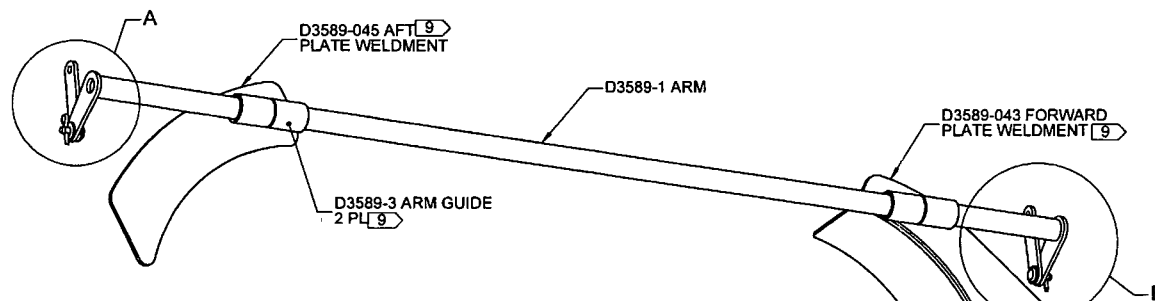
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

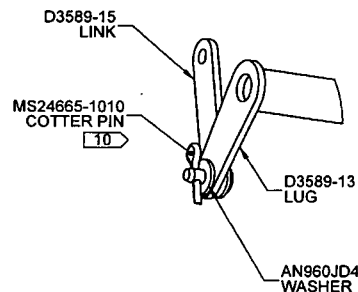
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

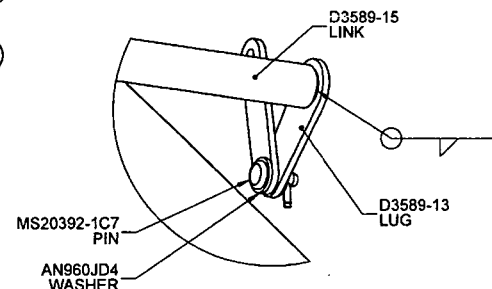
QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

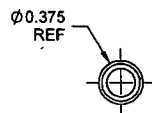
RELEASED
09/02/05

B	0.90 AND 0.83 REF WERE 1.97 AND 0.80 (ZN C8-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.08.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	A		
DRAWN	A		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	08.06.25		

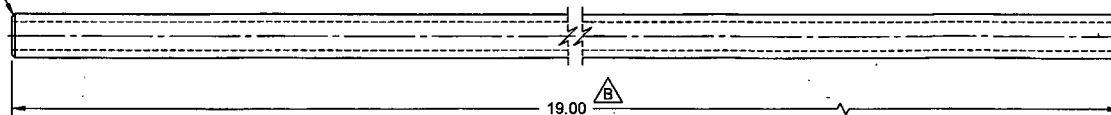
- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3589
REV. B
SHEET 1 OF 8
TITLE LATCH ASSEMBLY
SCALE NTS
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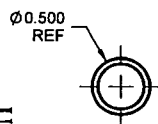


0.03 X 45°
CHAMFER
2 PL

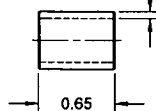


0.065
REF

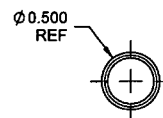
D3589-1 ARM



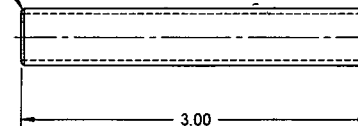
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

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WORK ORDER
NO. 4101801

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

RELEASED
9/22/25

DESIGN	<i>HA</i>	DART AEROSPACE LTD	
DRAWN	<i>HA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>HA</i>	DRAWING NO. D3589	REV. B
MFG. APPR.	<i>DS</i>	SHEET 4 OF 8	
APPROVED	<i>HA</i>	TITLE	SCALE
DE APPR.	<i>HA</i>	LATCH ASSEMBLY	
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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